

Work Order ID 66252

February 8, 2011 10:05:49 AM



Page 1

Item ID: D3202-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Cover

Start Date: 2/08/11 Start Qty: 10.00



Cust Item ID:

Required Date: 2/22/11 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: CL

Date: 11/02/08 Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3202

Rev D

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3202

Dwg Rev: 0

Prog Rev: 0

5652, 032

2-Deburr if necessary

11-2-17

10

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

11-2-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66252

February 8, 2011 10:05:49 AM

Page 2

Item ID: D3202-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Cover

Start Date: 2/08/11 Start Qty: 10.00

Cust Item ID:

Required Date: 2/22/11 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

140

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 1:40
OVEN TEMPERATURE: 320°
FINISH TIME: 2:10

710

10 / 11/04/23

10 BR 11-2-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66252

February 8, 2011 10:05:49 AM



Page 3

Item ID: D3202-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Cover

Start Date: 2/08/11 Start Qty: 10.00



Cust Item ID:

Required Date: 2/22/11 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150 QC3- Inspect Part Finish

0.00



QC Memo

0.00

Quality Control

10 of 11 2/22/11

160 Identify as per dwg & Stock Location 241A 0.00

Packaging Memo

0.00

Packaging

11/24/11 (10)

170 QC21- Final Inspection - Work Order Release 0.00



QC Memo

0.00

Quality Control

11/02/24 JF

MF

11-02-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February 8, 2011 10:05:49 AM

Page 1

Work Order ID: 66252

Parent Item: D3202-1

Parent Item Name: Cover



Start Date: 2/08/11

Required Date: 2/22/11

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:B No Longuer Made In House 05-11-06 JLM
 IPP Rev:C Now on Waterjet 07-04-18 JLM
 IPP Rev:D chg to revC as per dwg 08-04-21 DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M5052H32S.032		Purchased	No			100	sf	165.6600	1.551	16.32632			
---------------	--	-----------	----	--	--	-----	----	----------	-------	----------	--	--	--



5052-H32 .032 Sheet



11-2-17

Location	Loc Qty	Loc Code
MAT	16.8	
115638	16.8	
MAT23	148.86	
100470	3	
103321	2.76	
105998	5	
108462	6.3	
109478	9	
111448	3	
112664	20.8	
116657	96	
15031	3	

116657

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

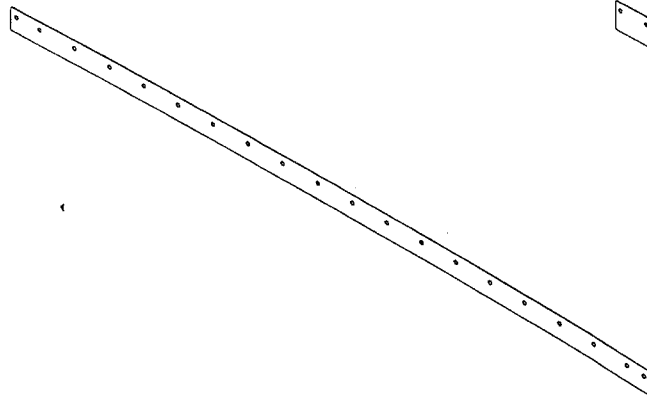
NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

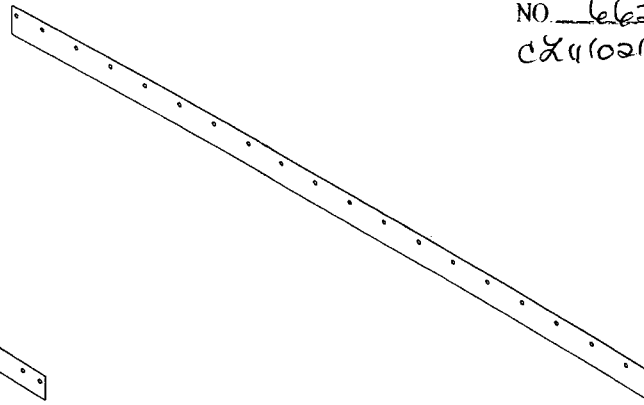
WITHOUT NOTICE
WORK ORDER

NO. 66252

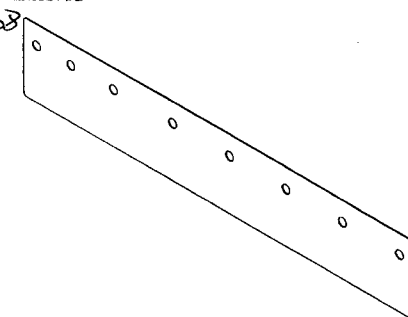
CX4102108



D3202-1 COVER



D3202-3 COVER
(COMPOSITE DOOR)



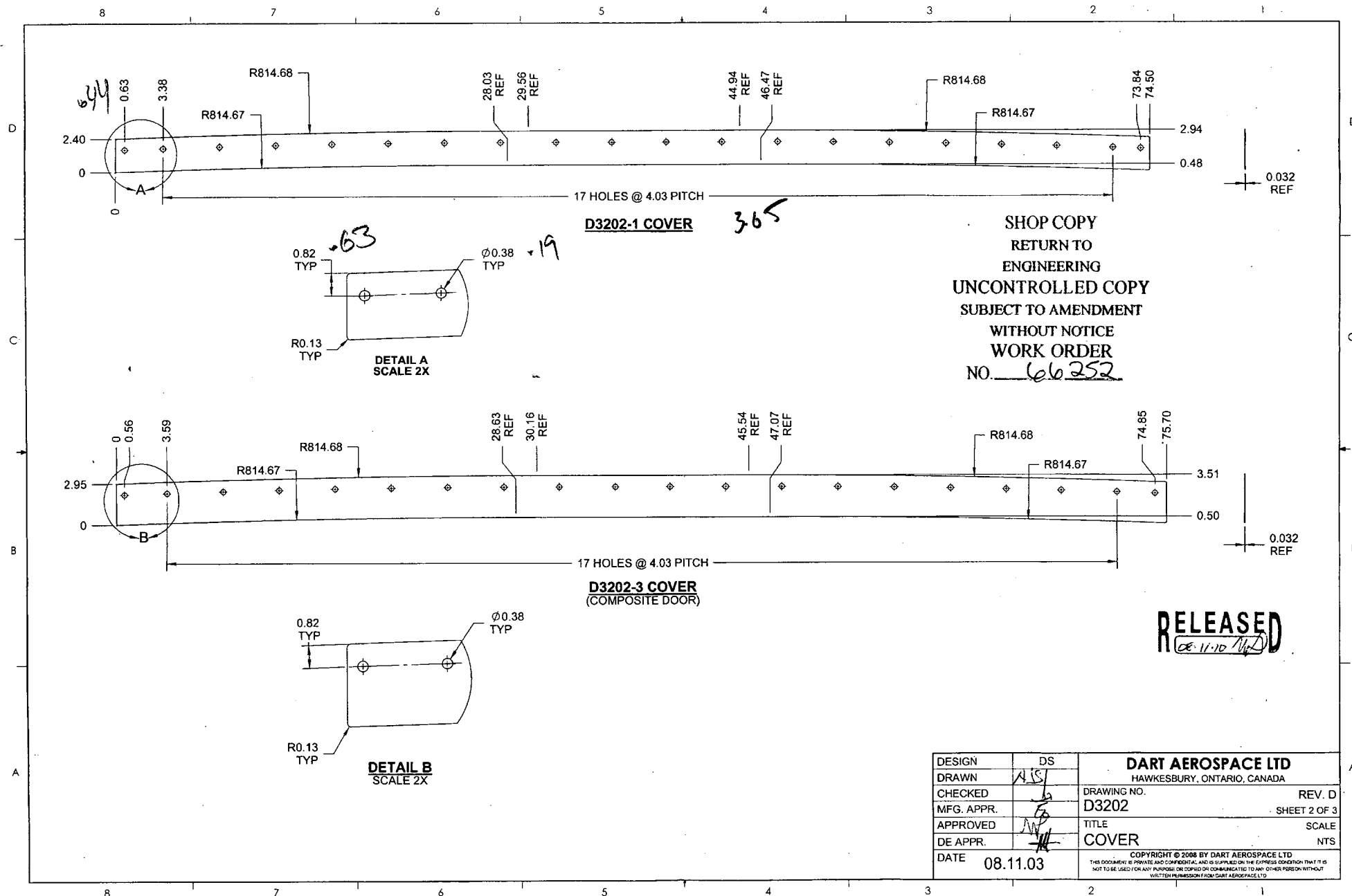
D3202-5 COVER
(HINGE PANEL DOOR MOD)

RELEASED
08.11.03

NOTES:

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET, 0.032 THICK
PER AMS-QQ-A-250/8 OR AMS 4016
REF. DART SPEC M5052H32S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDEXT (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3202-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.56 lbs APPROX FOR -1
: 0.61 lbs APPROX FOR -3
: 0.18 lbs APPROX FOR -5

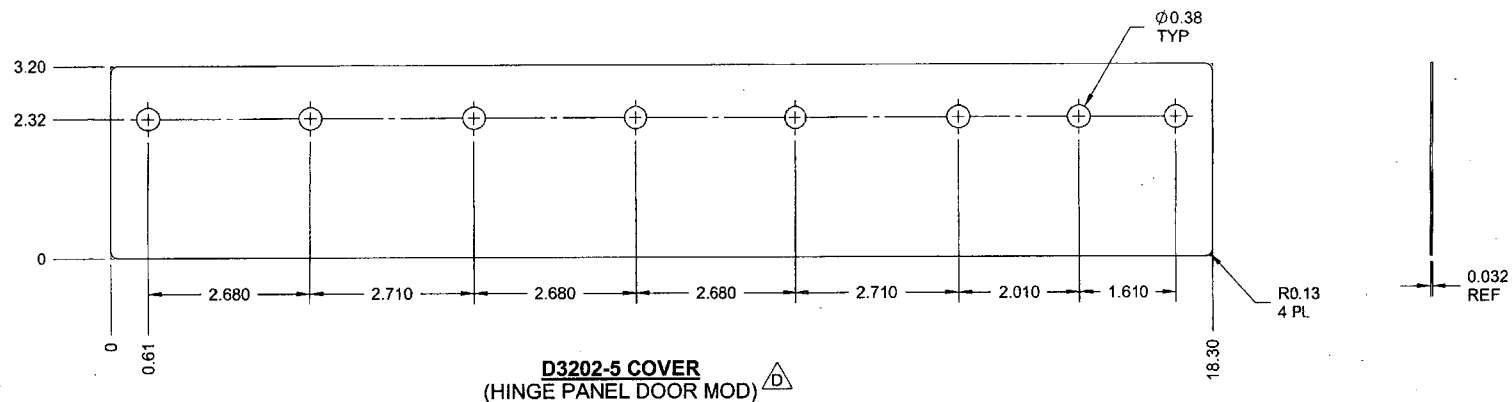
D	ADD -5 FOR HINGE PANEL DOOR MOD.	AJS	08.11.03
C	ADD -3 FOR COMPOSITE DOOR. REFORMAT ENTIRE DRAWING TO SOLIDWORKS STANDARD, INCORPORATE CHANGE B1 (CLARIFY MID-SPAN DIMENSION)	AJS	08.03.31
B	RE-DESIGN PART NOW CURVED	CP	03.10.16
A	NEW ISSUE	CP	01.01.01
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3202	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		COVER	NTS
DATE	08.11.03	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 66252

RELEASE
DE 11-10 M.D.

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	<i>NS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>NS</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>NS</i>	D3202	SHEET 2 OF
APPROVED	<i>NS</i>	TITLE	SCALE
DE APPR.	<i>NS</i>	COVER	NTS
DATE	08.11.03	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT	



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 66252

RELEASED
08.11.03

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3202	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		COVER	NTS
DATE	08.11.03	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	